

Date: Thursday, 6/15/2006 1:41:27 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE  
Job Number : 27557  
Estimate Number : 10299  
P.O. Number : N/A Part Number : D25775  
This Issue : 6/15/2006 S.O. No. : N/A Drawing Number : D2577 REV-E  
Prsht Rev. : NC Project Number : N/A  
First Issue : N/A Type : PURCHASED PARTS Drawing Revision : E  
Previous Run : 24199 Material : N/A  
Written By : *SA* Due Date : 6/30/2006 Qty: *33* Um: *30* Each  
Checked & Approved By : *SA 06-06-15*  
Comment : Est: F 02.09.24 Re-format KJ/RF  
Est Rev:D Now on Waterjet 06-06-14 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S16GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 1.0301 sf(s)/Unit Total : 51.5025 sf(s)

1010/1025 16GA SHEET

(m1010s16ga)

Batch: *M100473(22) M100473*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2577

Dwg Rev: *E*

Prog Rev: *E*

*SAD 06:06:28*

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2577-5T1

*SAD 06:06:28*

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*Ja 0718 33*

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

*SAD 06:07:18 33*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)                                   |                                  |  |                 |                           |                                  |                          |
|----------|------|--|----------------------------------|--|-----------------|---------------------------|----------------------------------|--------------------------|
| DATE     | STEP | Description of NC<br>Section A                                     | Corrective Action Section B      |  |                 | Verification<br>Section C | Approval<br>Design Mgr           | Approval<br>QC Inspector |
|          |      |  | Initial<br>Design Mgr            | Action Description<br>Design Mgr                                       | Sign &<br>Date  |                           |                                  |                          |
| 06.08.08 | 2.0  | 1 Part scrap. 1 hole way<br>out of tolerance, from<br>Welder Test. | CP<br>06.08.09<br>per<br>QSI 042 | <del>Use wear plate for weld</del><br>Use wear plate for weld<br>test. | SAD<br>06.07.18 | 2<br>06.02.18             | CP<br>06.08.09<br>per<br>QSI 042 | 2<br>06.06.28            |
|          |      |  |                                  |  |                 |                           |                                  |                          |
|          |      |  |                                  |  |                 |                           |                                  |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/08/09

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 6/15/2006 1:41:27 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 27557

Part Number: D25775

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake using DT8155 and DT8179 as per Dwg D2577

2-Form joggle using DT8157 as per Dwg D2577

3-Identify as D2577-5

33

SAN 06:07:19

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

SC 06/07/31  
DL

33

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 07 31

33

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP 19

DL 06/07/31

33

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/08/09

33

Job Completion



h 06-08-09

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

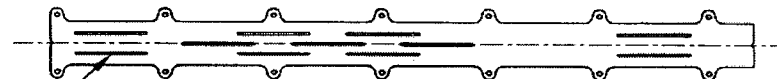
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



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00.04.26

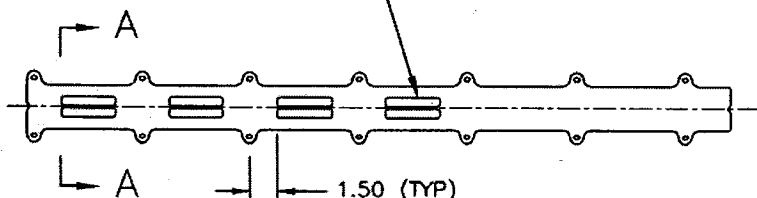
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|------------------|----------|---|---------------|
| CHECKED          | APPROVED | DRAWING NO.<br>D2577                              | SHEET 1 OF 5  |
| DATE<br>00.09.22 |          | TITLE<br>WEARSHOE                                 | SCALE<br>1:10 |
| A                | 36.09.16 | NEW ISSUE   |               |
| B                | 96.12.04 | ADD HARDCOAT WELDS                                |               |
| C                | 97.05.30 | CHANGE HOLES TO OBOUNDS                           |               |
| D                | 98.08.17 | CORRECTED DIMENSIONS ON -1 & -3                   |               |
| E                | 00.09.22 | ADD D2577-101/-11/-13<br>INCORPORATE DE09176      |               |

7560 HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308

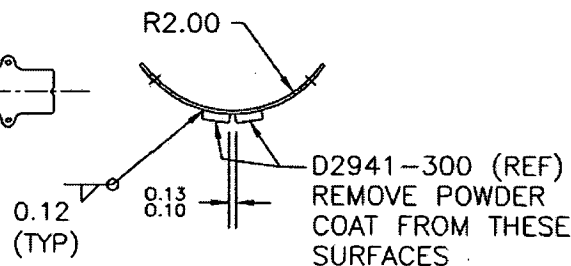


D2577-1 & D2577-3 WEARSHOE  
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY  
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2941-300  
SHWAYDER WEAPADS  
(8 PLACES)



SECTION A-A  
SCALE 1:5



D2577-21 & D2577-23 WEARSHOE  
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY  
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

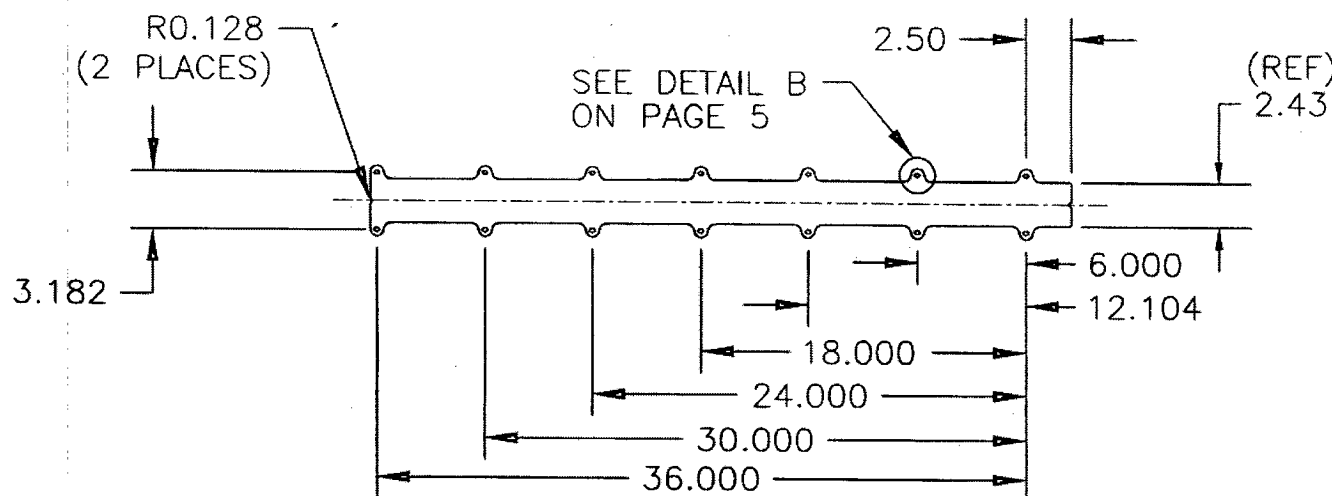
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WORK ORDER  
NO. 27557



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| ✓        | ✓        | D2577                       |
| DATE     | TITLE    | REV. E                      |
| 00.09.22 | WEARSHOE | SHEET 2 OF 5                |
|          |          | SCALE                       |
|          |          | 1:10                        |

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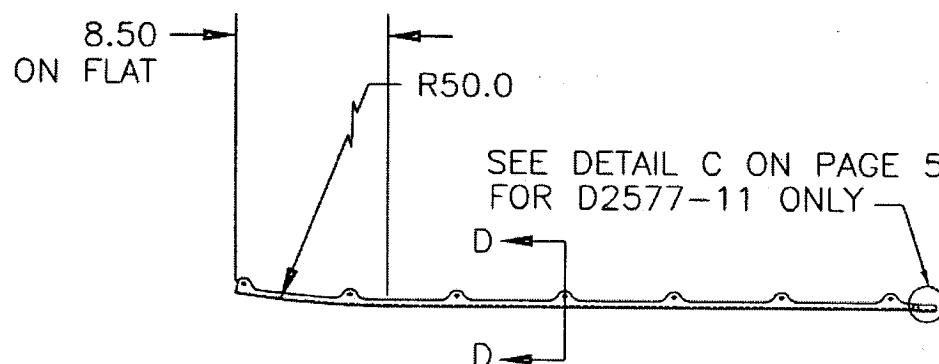
### D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



### D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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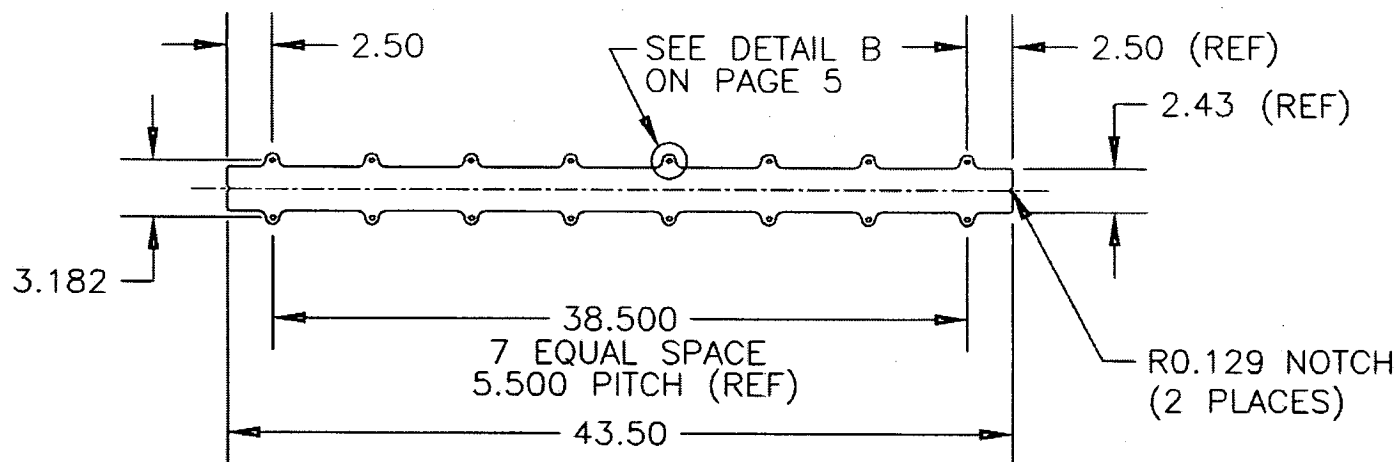
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WORK ORDER  
NO. 27557

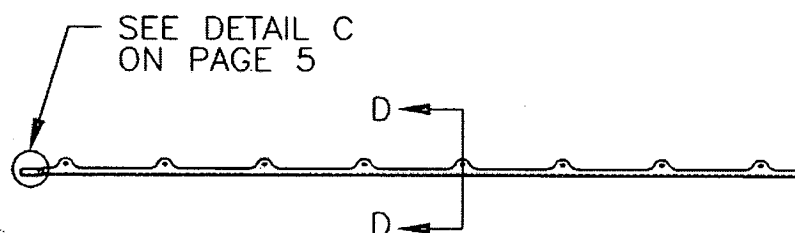


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| DATE     | DRAWING NO. | REV. E                      |
| 00.09.22 | D2577       | SHEET 3 OF 5                |
|          | TITLE       | SCALE                       |
|          | WEARSHOE    | 1:10                        |

### D2577-5 FLAT PATTERN



### D2577-5 LONGITUDINAL BEND



### D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570  
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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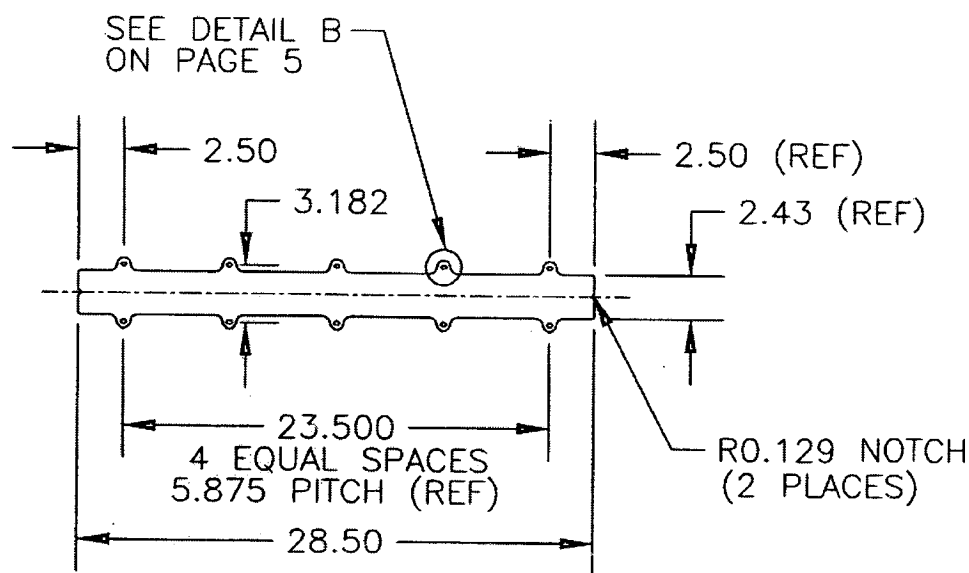
WORK ORDER  
NO. 27557



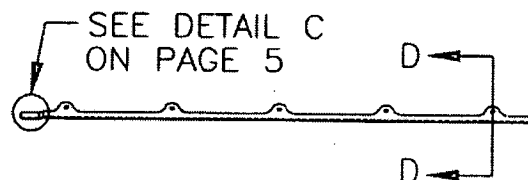
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| 00.09.22 | D2577       | SHEET 4 OF 5                |
|          | TITLE       | SCALE                       |
|          | WEARSHOE    | 1:10                        |

RELEASED  
00 09 26

### D2577-7 FLAT PATTERN



### D2577-7 LONGITUDINAL BEND



### D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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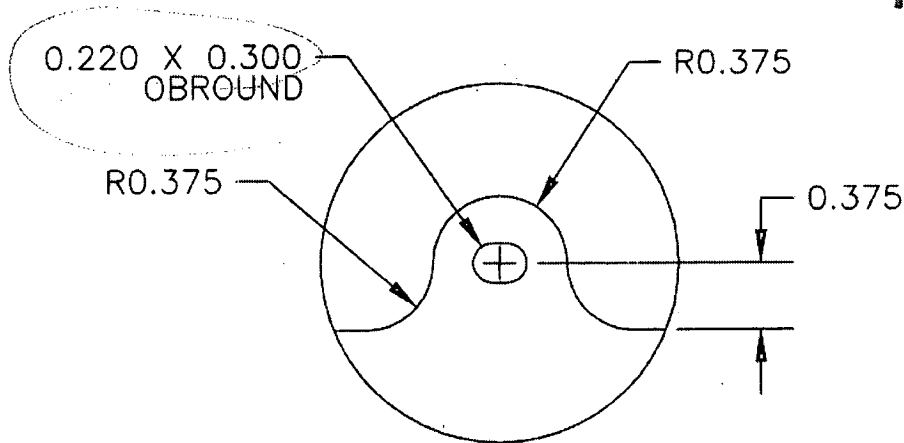




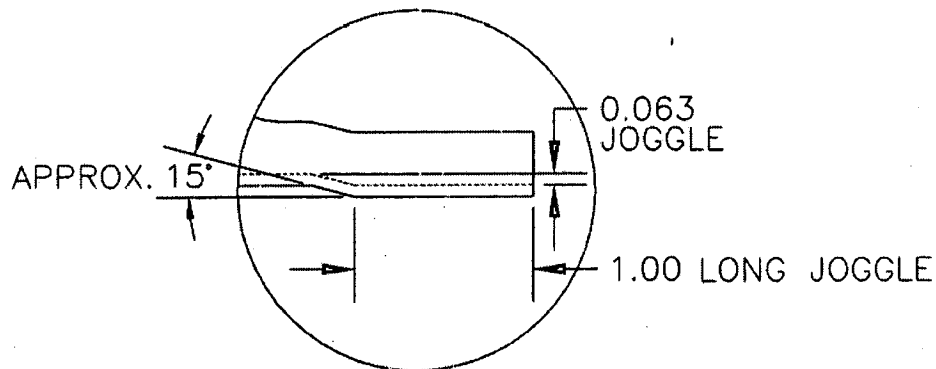
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| CHECKED<br>#     | APPROVED<br>#     | DRAWING NO.<br>D2577                              | REV. E<br>SHEET 5 OF 5 |
| DATE<br>00.09.22 | TITLE<br>WEARSHOE | SCALE<br>1:10                                     |                        |

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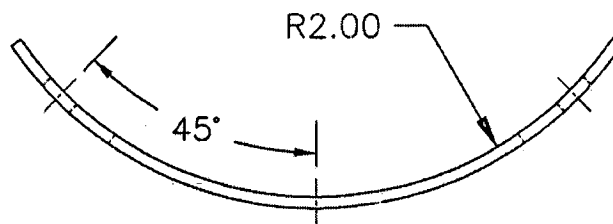
DETAIL B (SCALE 1:1)



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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WORK ORDER  
NO. 22557

